

Date: Thursday, 27/11/2008 2:23:46 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, INBOARD, RS, 206
Job Number : 43809	
Estimate Number : 10821	
P.O. Number :	Part Number : D26662
This Issue : 27/11/2008 S.O. No. :	Drawing Number : D2666 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 41976	Material :
Written By :	Due Date : 20/12/2008 Qty: 8 Um: Each
Checked & Approved By : <u>J.D. 08.11.27</u>	
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 .7075-T7351 2X6X6.25
 Issue material from stock:
 Cut Size 2.0 x 6.25 X 6.0
 Grain Along Long 6.0 Length

Batch No: B 34872 J.F. 08/12/29 (8)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program batch number.
 1-Inspect part number and batch number are programmed correctly.
 3-Fixturing Inspection last completed on _____ by _____
 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
 7- Deburr

J.F. 08/12/29 (8)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

J.F. 08/12/29 (8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:23:47 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 43809

Part Number: D26662

Job Number:



Seq. #: Machine Or Operation: Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/12/29

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

14 08/12/29

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

08/12/30

7.0

POWDER COATING

POWDER COATING



M109996



(8X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:00

OVEN TEMPERATURE:

320 OF

FINISH TIME:

9:30

M-L

08/12/30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FX 08/12/30

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

406

8/12/30

(8X)

SD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/05

Job Completion



MF 08-12-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43809	
Description: 206 Saddle, Inboard, Right side		Part Number: D2666-2	
Inspection Dwg: D2666 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.123"	.122"	.122"	.122"		
B	0.100	0.140		.108"	.108"	.108"	.108"		
C	2.470	2.510		2.492"	2.492"	2.492"	2.492"		
D	0.100	0.180		.135"	.135"	.135"	.135"		
E	0.210	0.230		.217"	.218"	.217"	.217"		
F	1.313	1.343		1.323"	1.323"	1.323"	1.323"		
G	0.240	0.260		.249"	.249"	.250"	.249"		
H	0.615	0.685		.651"	.651"	.651"	.651"		
I	1.125	1.145		1.135"	1.135"	1.134"	1.134"		
J	0.990	1.010		1.004"	1.004"	1.004"	1.004"		
K	0.235	0.240		.237"	.237"	.237"	.237"		
L	0.510	0.515		.510"	.510"	.510"	.510"		
M	0.100	0.120		.110"	.110"	.110"	.110"		
N	1.565	1.585	1.575	1.575"	1.575"	1.574"	1.574"		
O	5.990	6.010		5.999"	5.999"	5.999"	5.999"		
P	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
Q	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
R	0.490	0.510		.501"	.501"	.500"	.501"		
S	0.313	0.318		Ø.314"	Ø.314"	Ø.314"	Ø.314"		
T	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
U	1.357	1.367		1.364"	1.364"	1.364"	1.364"		
V	0.315	0.322		Ø.316"	Ø.316"	Ø.316"	Ø.316"		
W	0.540	0.560		.551"	.550"	.550"	.550"		
X	1.674	1.684		1.680"	1.680"	1.680"	1.680"		
Y	0.257	0.262		Ø.259"	Ø.259"	Ø.259"	Ø.259"		
Z	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F.
Date:	28/12/29

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 143809
Description: 206 Saddle, Inboard, Right side	Part Number: D2666-2
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.122"	.122"	.122"	.122"		
B	0.100	0.140		.107"	.107"	.107"	.106"		
C	2.470	2.510		2.492"	2.492"	2.492"	2.492"		
D	0.100	0.180		.135"	.135"	.135"	.135"		
E	0.210	0.230		.218"	.217"	.217"	.217"		
F	1.313	1.343		1.323"	1.323"	1.323"	1.323"		
G	0.240	0.260		.249"	.249"	.250"	.249"		
H	0.615	0.685		.651"	.651"	.651"	.651"		
I	1.125	1.145		1.134"	1.135"	1.135"	1.134"		
J	0.990	1.010		1.004"	1.004"	1.004"	1.004"		
K	0.235	0.240		.237"	.237"				
L	0.510	0.515		.510"	.510"				
M	0.100	0.120		.110"	.110"	.110"	.110"		
N	1.565	1.585		1.574"	1.575"	1.575"	1.574"		
O	5.990	6.010		5.999"	5.999"	5.999"	5.999"		
P	1.245	1.255		1.250"	1.250"				
Q	2.495	2.505		2.500"	2.500"				
R	0.490	0.510		.501"	.502"				
S	0.313	0.318		Ø.314"	Ø.314"	Ø.314"	Ø.314"		
T	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
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Y	0.257	0.262		Ø.259"	Ø.259"	Ø.259"	Ø.259"		
Z	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: J. F.
Date: 08/12/29

Audited by:
Date:

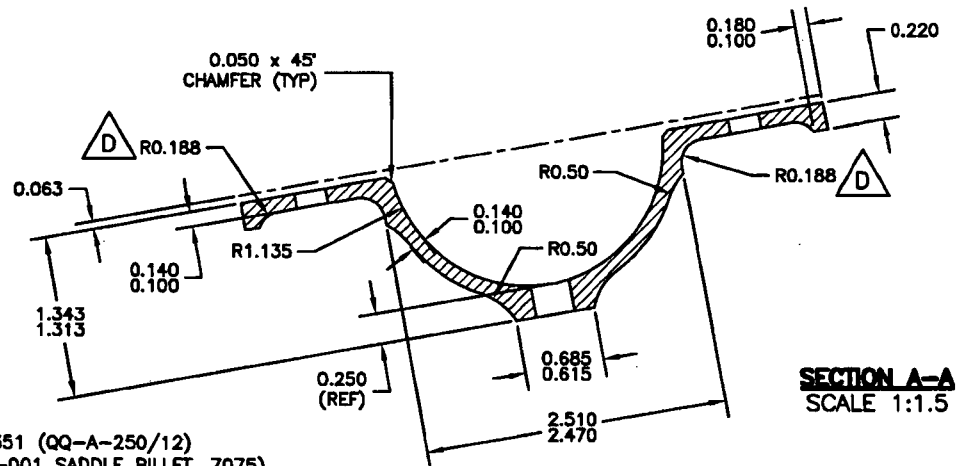
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

RELEASED

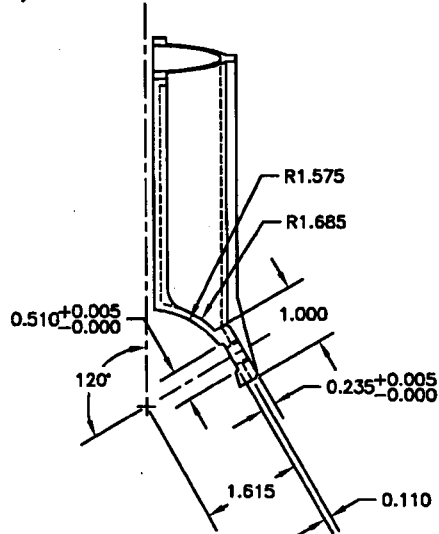
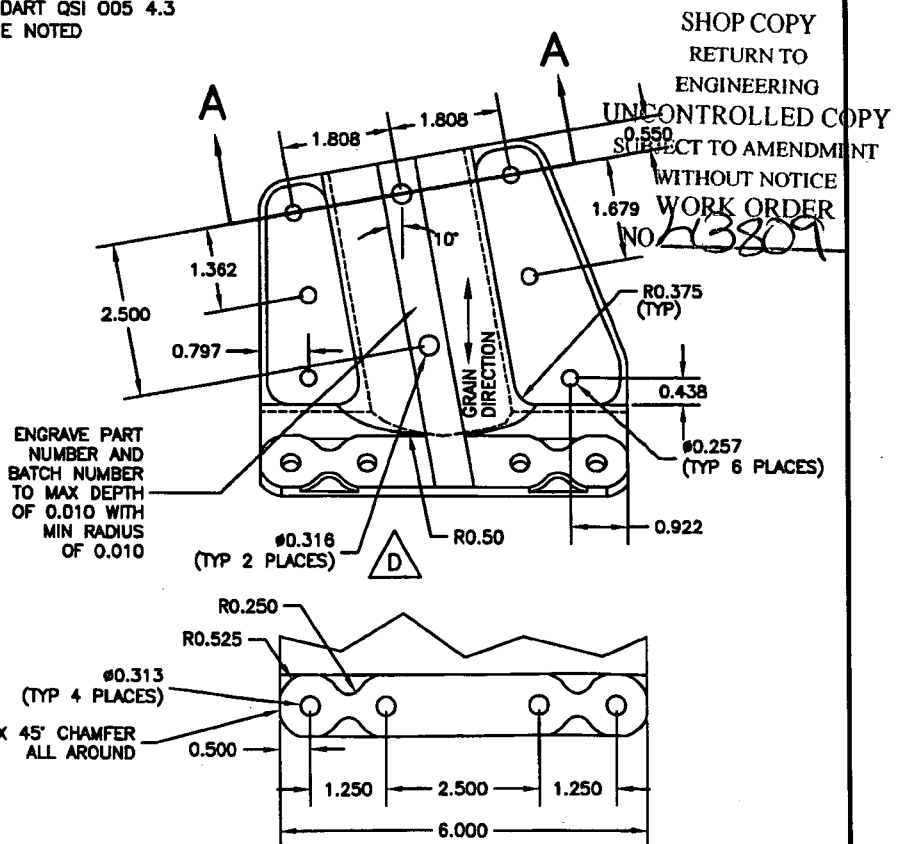
07-02-12

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED H	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

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